

Work Order ID 62556

Monday, October 04, 2010 10:58:44 AM

Page 1

Item ID: D350-591-213

Accept

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 10/4/2010 Start Qty: 3.00

Required Date: 10/20/2010 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

8/10/11/14

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

10.11.04

3

P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

QC6

Memo

0.00

8/10/10/05

3

PTC

130



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072
A/R Aluminum Rod M108436
3-Grind End Plate flush M114877

10-11-05

3

0

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

3 0 8E10/11/09

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect part completeness to step on W/O

0.00



QC3 QC5
Memo

0.00

QC

Quality Control

Solulog

43
LH

P10 →

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10.11.09

3

8

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

3 10-11-09

W/O: 62556		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/11/09	# 150 120	perm. change change step # 150 QCS to QCG inspect n				<i>[Signature]</i> 10-11-11	S 10/11/09	
10-11-11	210	QCG change to QCI0 → AFT cap is ground weld: not a critical weld perm change	<i>[Signature]</i>	10-11-17		<i>[Signature]</i> 10/11-11	<i>[Signature]</i> 10-11-11	

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



Large Fab

Large Fab

Large Fab

Memo:

- 1- Rivet Leg Assembly as per Dwg D3078.
- 2-Bevel Aft end for welding
- 3-Inspect for foreign object as per QSI 024
- 4-Weld Aft End Plate as per QSI 004 & Dwg D3078
- A/R Aluminum Rod M108436
- 5-Grind End Plate flush

0.00

0.00

10.11.10

3

Ø

210



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

QC10

Memo

0.00

0.00

3

Ø

BE 10/11/11

P10
prev. was
page
←

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

QC5

Memo

0.00

0.00

S1061u

(+3)
46

100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/09	# 270	Perm. change change step to QAC inspection					<i>[Signature]</i> 10/10/09	

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

Chemical Conversion Coat per QSI005 4.1

0.00

=> 10/11/11

3/4

0



HandFinish

Memo

0.00

Hand Finishing

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115291

Memo

0.00

Powder Coating

START TIME: 10:10
OVEN TEMPERATURE: 320°
FINISH TIME: 10:40

3/4

10-11-15

250

Wing Walk as per dwg QSI005 4.4 Batch M115790

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/11/16

3

0

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/10/16

x3
41

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/16 (A30)

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/16

x3
41

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 10/20/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-213

Location: 30PPP Rev: E

300

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/11/16 SP 34

10/11/17

MF
10-11-16

W/O:		WORK ORDER CHANGES					
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Monday, October 04, 2010 10:58:48 AM

Parent Item: D350-591-213




Parent Item Name: Heli-Access-Step, Short LH

Start Date: 10/4/2010**Required Date:** 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D
10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			110	Each	156.4200	0.5	1.5		10.11.04	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				156.42					
				55214				3.42					
				58544				25					
				<u>61208</u>				128		1.5			
D3067-1  End Plate		Manufactured	No			130	Each	72.0000	1	3		10.11.05	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				72		3			
				<u>60141</u>				72					
D3063-1  Support		Manufactured	No			130	Each	38.0000	1	3		10.11.05	
				<u>Location</u>				<u>Loc Qty</u>					
				WA				38					
				59663				38		3			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 62556

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

MS20600-AD4W4

Purchased

No

180

Each

1,699.000

16

48



Rivets

Location

Loc Qty

Loc Code

ST321

1699

113368

62

114181

11

114718

2

115573

624

115640

1000

D3066-1

Manufactured

No

180

Each

83.0000

2



Spacer

Location

Loc Qty

Loc Code

WA

B62462

83

60194

35

61205

48

D3065-041

Manufactured

No

180

Each

53.0000

1



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

53

60200

14

61216

39

D3067-1

Manufactured

No

200

Each

72.0000

1



End Plate

Location

Loc Qty

Loc Code

WA

B62664

72

60141

72

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Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

AN3-35A

Purchased

No

270

Each

90.0000

2



Bolt



6
10/11/10 SP M45936

Location

Loc Qty

Loc Code

ST353

90

115108

40

115457

50

D2856-400

Manufactured

No

270

f

276.3760

0.6



Abraison Strip



1.8
10/11/10 SP

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920

213.12

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A

Purchased

No

270

Each

420.0000

6



Bolt



18
10/11/10 SP

Location

Loc Qty

Loc Code

ST357

420

110382

220

115316

200

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

24.0000

12



Washer



36
M116025 10/11/10 SP (4x)

Location

Loc Qty

Loc Code

ST300

24

113288

24

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Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

D2230-1

Manufactured No

270

Each

87.0000

2



Lug



B62668 10/11/10

Location

Loc Qty

Loc Code

ST476

87

60289

27

61713

60

MS21042L3

Purchased No

270

Each

1,720.000

2



Nut



10/11/10

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

AN4-13A

Purchased No

270

Each

480.0000

4



Bolt



12

M116075 10/11/10

Location

Loc Qty

Loc Code

ST358

480

115159

480

D2732

Manufactured No

270

f

227.6657

1



Rubber Extrusion



3.157895

10/11/10 30

Location

Loc Qty

Loc Code

ST412

227.665737

43118

2.5

56516

225.165737

cut qty of 4 at 3.00" as per dwg(D2732-030)

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Required Date: 10/20/2010

Start Qty: 3.00

Required Qty: 3.00

D2230-3

Manufactured No

270

Each

70.0000

2

6



Lug



362600 10/11/10

Location

Loc Qty

Loc Code

ST476

70

55452

2

60846

68

AN960JD10

NAS1149D0363J

Purchased

No

270

Each

8.0000

4

12



Washer



1115622 10/11/10

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

MS21042L4

Purchased

No

270

Each

4,434.000

6

18



Nut



10/11/10 sl 30

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

18

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Start Qty: 3.00

Required Qty: 3.00

AN4-16A

Purchased

No

270

Each

276.0000

4

12



10/11/10 SP (3x)

Bolt

Location

Loc Qty

Loc Code

ST360

276

115016

21

115159

50

115374

105

115422

100

5

W/O:		WORK ORDER CHANGES					
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.01.20 *#*

SHOP COPY
REV. A
FOR
UNCONTROLLED
SUBMIT
V. 1.0
W. 1.0
NO. 42554 *01101004*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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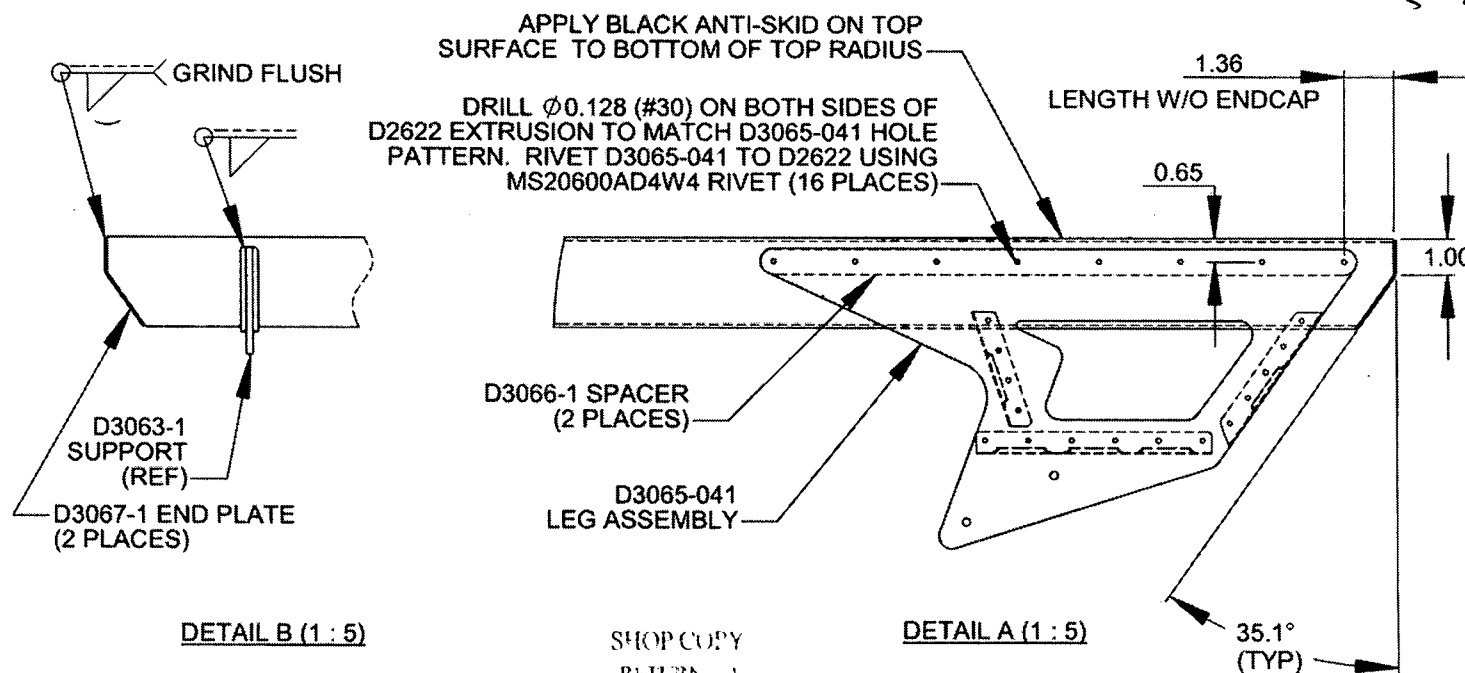
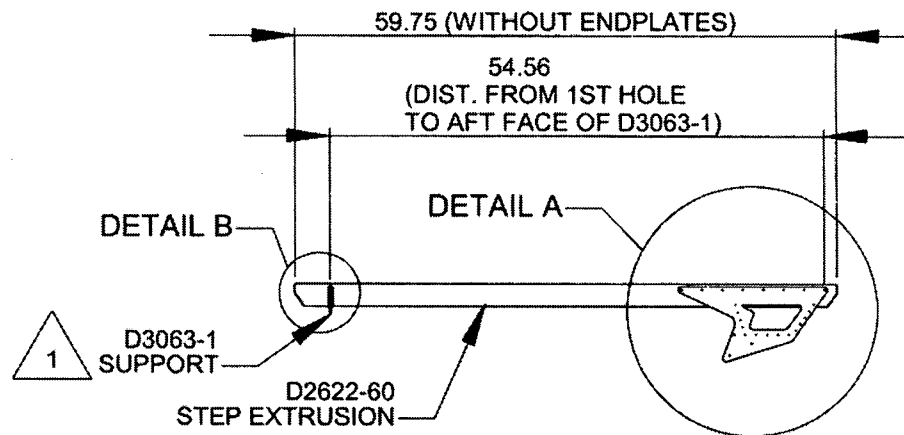
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DATE	DRAWING NO.	REV. A
02.09.11	D3078	SHEET 2 OF 2
TITLE	SCALE	
STEP ASSEMBLY, HI SHORT	1:20	

RELEASED
02.09.2004

57.750
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DETAIL B (1:5)

DETAIL A (1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE


For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.



For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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